

Work Order ID 130136

Tuesday, February 24, 2015 1:01:00 PM

130136

Page 1

Item ID: D350-589-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Assembly - RH

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *1502-24* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2991

D

IIN-D350-589

E

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-589-042 CHG005

103

0.00

103

Small Fab

Memo

0.00

Small Fab

1- Trim edge of door to fit moc up helicopter and touch up with primer and paint if necessary

**DAS
02
9-89***15-07-21*

Work Order ID 130136

Tuesday, February 24, 2015 1:01:00 PM

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Page 2

Item ID: D350-589-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Assembly - RH

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

① 15-57-21 PD.

110

Spray Painting per QSI005 4.2

0.00

110

SprayPaint

Memo

0.00

Spray Painting

touch up with primer and paint if necessary

Primer Batch: 132072

Paint Batch: N/A

DAS

41

9-88

15-7-22

120

QC14- Inspect Spray Paint

0.00

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 16/05/10 Date: 16/05/10Work Order update only ☐

Work Order: <u>130136</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No: <u>D3085-041</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No: <u>16-5769</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☒	Supplier ☐		

Date: 2015/07/21 Step #: 110 QTY Effective: x1 MRB (QSI042) Approval 15/7/21 DAS 12 9:59

Description Work Order Deviation	Disposition	MRB (QSI042) Approval
holes for D3085-041 prop Assy supposed to measure 1.500". actual measurement is 1.562". Cannot line up holes to install prop Assy. Re. Standard issue w/ composite Darts. Supplier issue But Part is normal work!	countersink both sides of one hole .375" x 1.00". Fill hole with Hysol 934NA and 10% milled Fiber. sand Flush + re-prime inside and outside of door using Axalta/Cromax LE3404S grey primer filler Hysol B# <u>131581</u> milled fiber B# <u>100859</u> primer filler B# <u>132072</u>	Completed By <u>DAS</u> <u>02</u> <u>089/15-07-21</u> Lead hand / Supervisor Approval Verification <u>ED 15.07.21</u> QC / QA Coordinator Approval <u>15/07/21</u>

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	☒ Outside Dimensions
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	☒ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____			
Misidentified ☐	Past Due ☐				

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Item ID: D350-589-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Assembly - RH

Start Date: 2/24/2015 Start Qty: 1.00

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Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Small Fab

0.00

Small Fab

Memo

Small Fab

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

D40 →

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DQA:

Date:

16.05.16



QA Closed:

Date:

16/05/10

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>130136</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3085041</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5770</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☒	Supplier ☐			
Date: <u>15.07.22</u>		Step #: <u>140</u>		QTY Effective: <u>(1)</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			5/15/07/22		
re-drilled 0.191" hole in wrong location through one side of skin only + into foam core				Fill void using Hysol 934NA with 10% milled Fiber allow to cure sand Flush + touch up primer Hysol <u>B 131581</u> milled fiber <u>B 100859</u> primer Filler <u>B 132072</u> as per QSI 037 section 9.8			Completed By: <u>(Signature)</u> DAS 02 15-07-22 Lead hand / Supervisor Approval Verification <u>(Signature)</u> QC / QA Coordinator Approval 5/15/07/22		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☒	Positioned Wrong ☒				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Stop ***NR2***

[illegible]

Picklist Print

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Work Order ID: 130136

130136

Parent Item: D350-589-042

D350-589-042

Parent Item Name: Side Door Assembly - RH

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD IPP rev:D 10.04.29 revise bom
 per(w/o 47622)perm, chg DD
 verified:EC IPP Rev:E add
 seq 103/105 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2991-2		Manufactured	No			140	Each	1.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2991-2

Side Door

130137

**

DAS
02
9-89

15-07-21

Location	Loc Qty	Loc Code
----------	---------	----------

MF	1	
113434	1	

NAS1149D0363J		Purchased	No			140	Each	3,009.000	3	3			
---------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

NAS1149D0363.J

Washer

132317

**

DAS
02
9-89

15-07-21

Location	Loc Qty	Loc Code
----------	---------	----------

CA	569	
m130799	569	
FP001	14	
113288	14	
QA	426	
m128429	426	
ST269	2000	
m131618	2000	

Picklist Print

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Work Order ID: 130136

130136

Parent Item: D350-589-042

D350-589-042

Parent Item Name: Side Door Assembly - RH

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3894-1 Manufactured No

160 Each 3.0000 1 1

D3894-1******

Doubler

LocationLoc QtyLoc Code

ST064

3

46896

3

D3895-1 Manufactured No

160 Each 10.0000 1 1

D3895-1******

Doubler

LocationLoc QtyLoc Code

ST064

10

53964

10

D2621 Manufactured No

140 Each 46.0000 3 3

D2621******

Latch Plate

LocationLoc QtyLoc Code

FG

2

88616

2

ST008A

20

123542

20

ST012a

24

127749

24

DAS
02
9-89

15-07-21

x 3

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Work Order ID: 130136

130136

Parent Item: D350-589-042

D350-589-042

Parent Item Name: Side Door Assembly - RH

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No

140 Each

109.0000 3 3

D2586

Door Latch

**

DAS
02
9-89

15-07-21

Location	Loc Qty	Loc Code
FG	16	
100607	1	
114985	5	
119746	4	
83893	5	
95760	1	
ST482	48	
128416	48	
ST488a	45	
129404	45	x3

MS27039-1-15

Purchased No

140 Each

171.0000 3 3

MS27039-1-15

Screw

**

DAS
02
9-89

15 07 21

Location	Loc Qty	Loc Code
GA	99	
m127916	99	
ST285	72	
m127916	72	x3

D2464-1700

Manufactured No

140 Each

0.0000 1 1

D2464-1700

Seal-170"

**

DAS
02
9-89

15-07-21

D3085-041

Manufactured No

140 Each

2.0000 1 1

D3085-041

Prop Ass'y

**

DAS
02
9-89

15-07-21

Location	Loc Qty	Loc Code
ST370	2	
86959	2	

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Work Order ID: 130136

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Parent Item: D350-589-042

D350-589-042

Parent Item Name: Side Door Assembly - RH

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2585 Manufactured No

140 Each

44.0000 3 3

D2585

Latch Clamp

132766

**

DAS

02

9-89

15-07-21

Location

Loc Qty

Loc Code

ST008

44

127709

44

MS21042L3 Purchased No

140 Each

2,744.000 3 3

MS21042L3

Nut

132382

**

DAS

02

9-89

15-07-21

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

996

M131317

996

ST305

1328

112385

7

113537

15

116549

22

M131264

545

M131624

739

MS20470AD4-5 Purchased No

160 Each

2,376.000 6 6

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

Location

Loc Qty

Loc Code

GA

2208

m128401

2176

m128813

32

ST310

168

m128813

168

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Picklist Print

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Work Order ID: 130136

Parent Item: D350-589-042

Parent Item Name: Side Door Assembly - RH

130136

D350-589-042

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-4A	Purchased	No	160	Each	260.0000	6	6
--------	-----------	----	-----	------	----------	---	---

AN3-4A

Bolt

Location

Loc Qty

Loc Code

CA	108	
m129682	108	
ST350	152	
m129702	152	

D2237	Manufactured	No	160	Each	64.0000	3	3
-------	--------------	----	-----	------	---------	---	---

D2237

Striker Plate

Location

Loc Qty

Loc Code

ST005	64	
121746	34	
128358	30	

D2589	Manufactured	No	160	Each	11.0000	1	1
-------	--------------	----	-----	------	---------	---	---

D2589

Keys, Key Chain

Location

Loc Qty

Loc Code

ST008	11	
123246	11	

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Picklist Print

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Work Order ID: 130136

Parent Item: D350-589-042

Parent Item Name: Side Door Assembly - RH

130136

D350-589-042

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

2,744.000

6

6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

996

M131317

996

ST305

1328

112385

7

113537

15

116549

22

M131264

545

M131624

739

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Shop Packet Print

Page 6

D2991-1/-2/-3 SIDE DOOR

NOTES

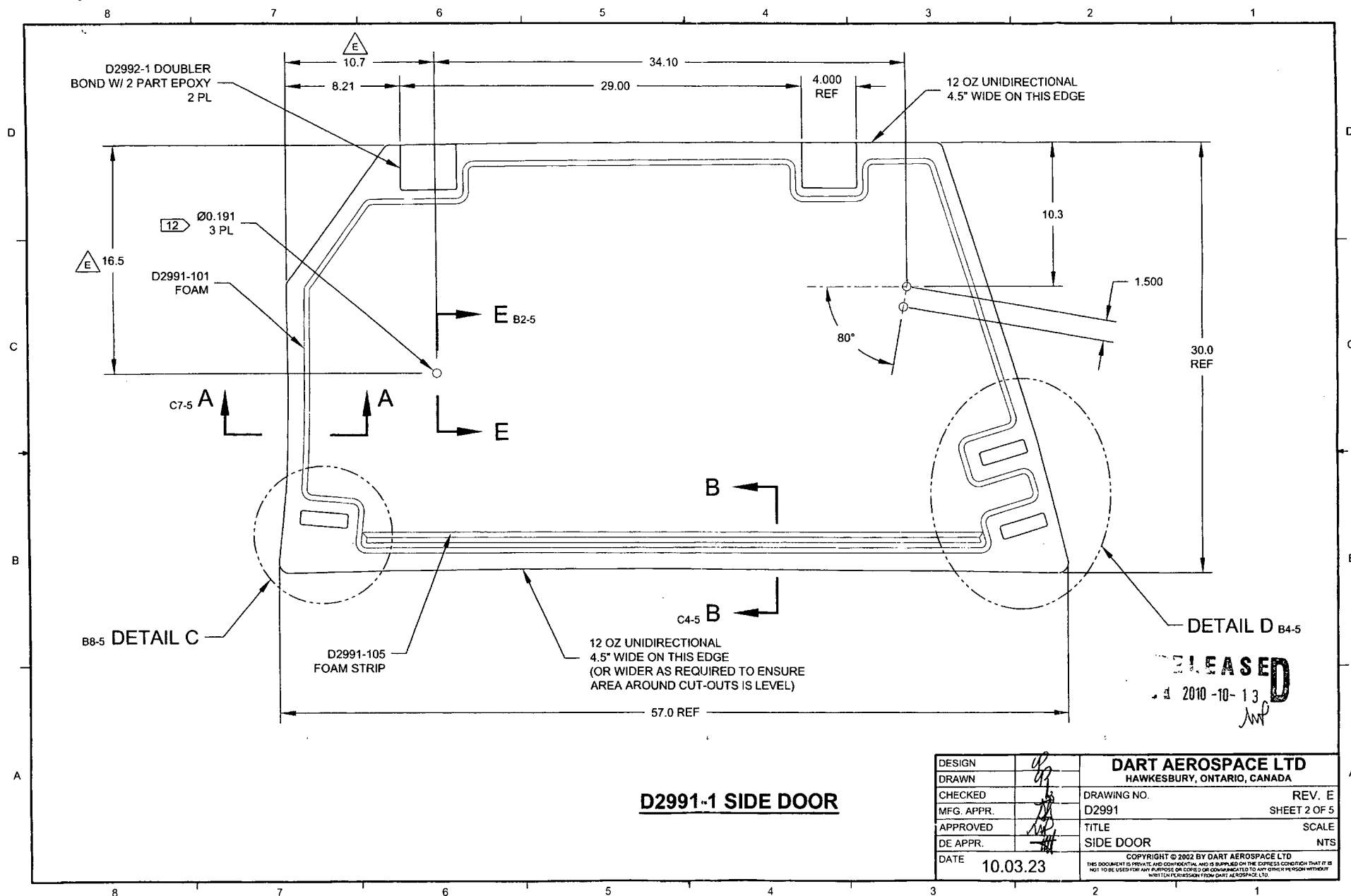
- 1) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 2) FINISH: FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9 lbs TYP
- 8) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 9) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 10) LAYUP PER QSI 006 AND AS FOLLOWS:

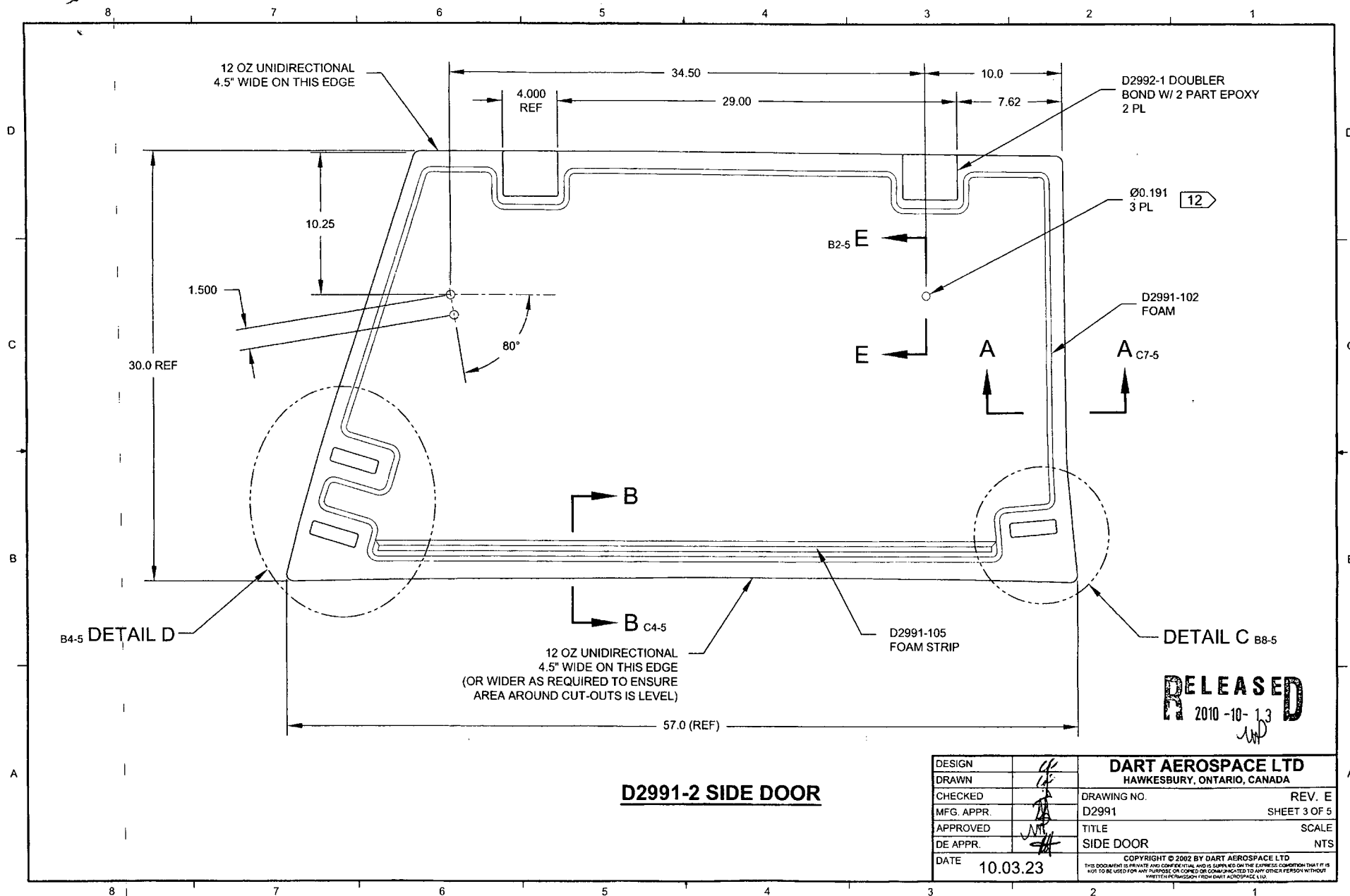
MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 11) BOND FOAM CORE USING POLYBOND B46F
- 12) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956AB MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.

COPY
130136 MLC
1502-24

RELEASED
2010-10-13

E	REFORMAT, MOVE HOLE: 16.5 WAS 10.25 (ZN C8-2) 10.7 WAS 10.2 (ZN D7-2), PAR 10-007	CP	10.03.23
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED	DRAWING NO.		REV. E
MFG. APPR.	D2991		SHEET 1 OF 5
APPROVED	TITLE		SCALE
DE APPR.	SIDE DOOR		NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

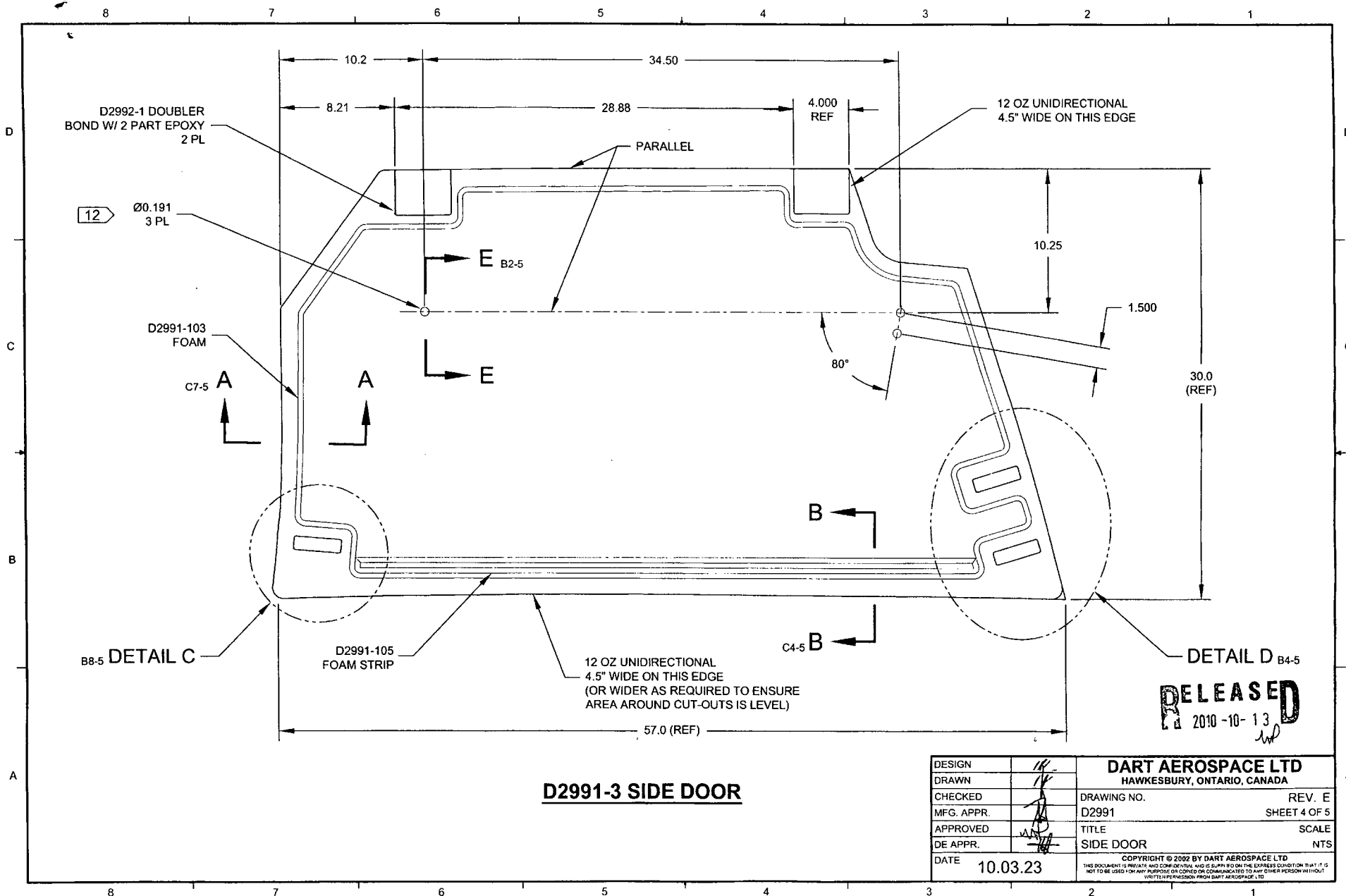


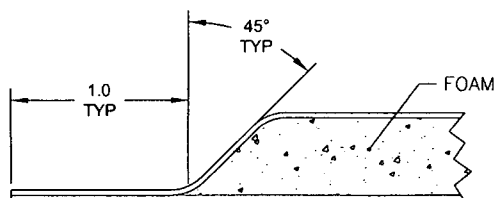


D2991-2 SIDE DOOR

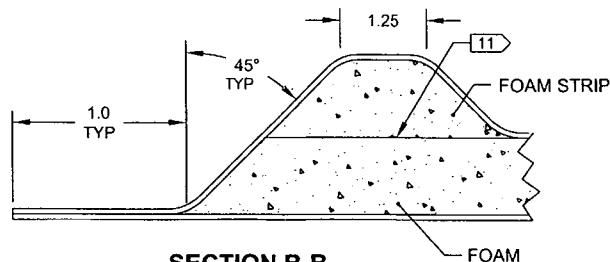
RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2991	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

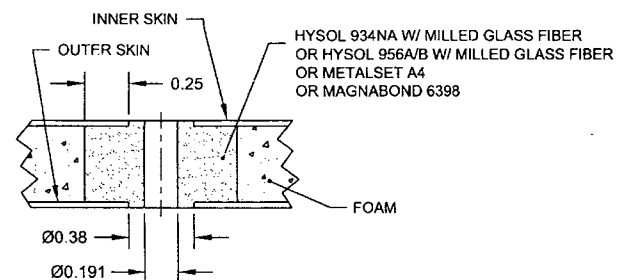




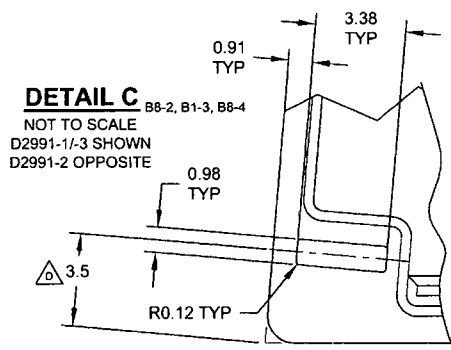
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



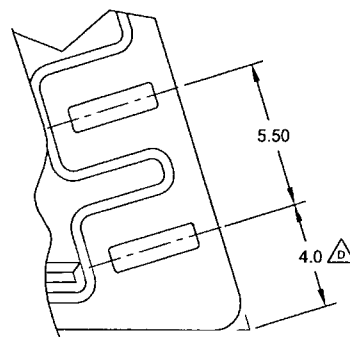
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B6-2, B1-3, B6-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B6-3, B1-4
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE

RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
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